

**Work Order ID 67677**

Page 1

Tuesday, March 29, 2011 11:15:59 AM

Item ID: D4000-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Pickup Fitting

Start Date: 3/29/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*Handwritten signature*Date: *11-03-29*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4000

A

100

0.00



Doosan

0.00

Doosan Lathe

Memo

Turn as per DWG and Folio Fa905

Folio Rev: *Handwritten*Dwg Rev: *Handwritten*

\*\*USE DIE TO TEST THREADS ON PARTS\*\*\*

Deburr

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

*Handwritten: ml 11.4.6**Handwritten: 4**Handwritten: ml 11.4.6**Handwritten: 4*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 67677**

Tuesday, March 29, 2011 11:15:59 AM



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Item ID: D4000-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Pickup Fitting

Start Date: 3/29/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00



QC

Memo

Quality Control

0.00

11/4/6

4

0

130

Identify as per dwg & Stock Location: UA

0.00



Packaging

Memo

Packaging

0.00

11-05-02

4

0

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

0.00

11/5/3

11-05-3

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, March 29, 2011 11:16:05 AM

Page 1

Work Order ID: 67677



Parent Item: D4000-7

Parent Item Name: Fuel Pickup Fitting

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: Ipp Rev:A New Issue 10-01-28 JLM Verified By:EC IPP rev B 10.05.13  
ecn10-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6R1.500

Purchased

No

100

f

10.5800

0.131

0.524



11-4-6

6061-T6 Round Bar 1.50

Location

Loc Qty

Loc Code

MAT013

10.58

110167

10.58

583

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 67677
Description: fuel pick up fitting		Part Number: D4000-7
Inspection Dwg:	Rev:	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article

☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.217	+/- .010	.215	/		2p. 02	
.04 x 45°	+/- .030	.040	/			
R.66	+/- .030	.659	/			
1.05 φ	+/- .030	1.048	/			
1.05	+/- .030	1.051	/			
1.16	+/- .030	1.160	/			
.39 ref	+/- .030	.390	/			
.51 φ	+ .010 - 0.0	.515	/			
1.00	+/- .030	1.002	/		Pipe Thread gage. Pipe Thread gage.	
.57	+/- .030	.577	/			
1/4 NPT	+/- 1 turn	+ 1/2 turn	/			
3/4 NPT	+/- 1 turn	- 1/2 turn	/			

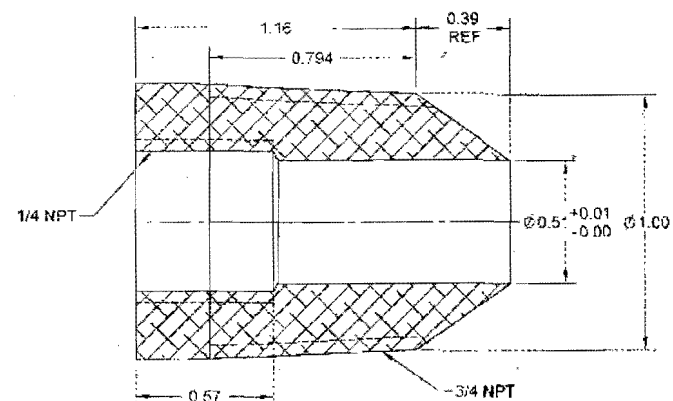
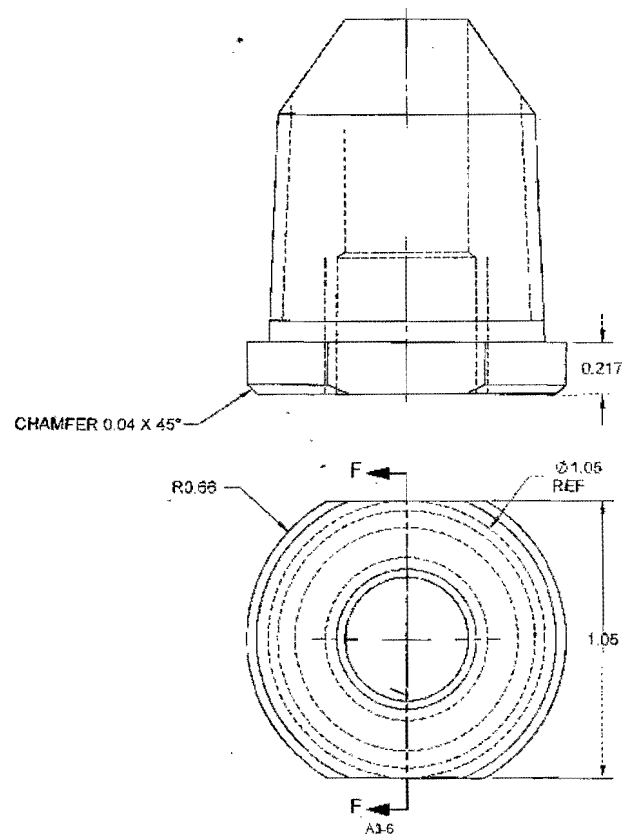
Measured by: <i>ml</i>	Audited by: <i>EA</i>	Prototype Approval:
Date: 11-4-6	Date: 11/4/6	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-7	REF JCA-M47-1-10



SECTION F-F  
A6-6

**D4000-7 FUEL PICK UP FITTING**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

**RELEASED**  
2010-05-05  
JMP

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWN	<i>[Signature]</i>		SHEET 6 OF 6
CHECKED	<i>[Signature]</i>	DRAWING NO. D4000	SCALE
MFG. APPR.	<i>[Signature]</i>	TITLE FITTING	NTS
APPROVED	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD ALL RIGHTS RESERVED. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.	
DATE	10.02.10		

